

Work Order ID 86339

86339

Page 1

June-27-12 3:19:01 PM

Item ID: D206-559-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9527	rev A								
IIN-D206-559	rev L								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPD206-559-011 CHG007

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DA 16 12/06/13 JB

JJ for CL 12-7-6

5 12/07/06 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D206-559-011

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
12/13

75

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-011

Location: 11

5x

Sp
12-7-13

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/7/18

mf
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-27-12 3:19:05 PM

Page 1

Work Order ID: 86339

86339

Parent Item: D206-559-011

D206-559-011

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:C04.02.17Blank size changedKJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-05-05 up a chg DD verified by:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified

By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A
AN4-17A
Bolt

Purchased

No

160

Each

562.0000

8
**

40

JB

Location

Loc Qty

Loc Code

ST358

300

116704

0

121541

300

ST359

262

112314

0

121011

200

121068

62

121011

AN4-20A
AN4-20A
Bolt

Purchased

No

160

Each

505.0000

8
**

40

JB 12/07/06

Location

Loc Qty

Loc Code

GA

50

116419

50

ST359

455

117514

51

121060

104

121541

300

121060

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 86339

Parent Item: D206-559-011

Parent Item Name: Bearpaw

86339

D206-559-011

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased No

160 Each 31.0000 16 80 ✓

AN960JD416

Washer

**

121912 JB

SP

Location

Loc Qty

Loc Code

ST351 31
116289 10
119097 21

D2182B Manufactured No

160 f 122.8682 1.666 8.33 ✓

D2182B

Rubber Cushion

**

JB SP

Location

Loc Qty

Loc Code

ST410 122.86817
63413 1.6
66063 41.61817
73932 79.65

(D2482B050) Gut(4) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each 759.0000 8 40 ✓

D2274

Radius Block

**

JB SP

Location

Loc Qty

Loc Code

ST007 759
78233 2
81958 96
83258 210
84199 251
85455 200

D2435 Manufactured No

160 Each 0.0000 12 10

D2435

Bearpaw, 206

**

84199

84012 12/07/06

June-27-12 3:19:05 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-27-12 3:19:05 PM

Page 3

Work Order ID: 86339

86339

Parent Item: D206-559-011

D206-559-011

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 5.00

Required Qty: 5.00

D2438

Manufactured No

160 Each

142.0000



20



**

7x86871

JB



D2438

Clamp

Location

Loc Qty

Loc Code

ST456

142

77038

6

83265

28

83266

50

84804

58

D2529

Manufactured No

160 Each

761.0000



40



**

13x84804

JB



D2529

Washer

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

81873

MS21042L4

Purchased No

160 Each

1,920.000



40



**

8

JB 12/08/06

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

1920

119075

116

121011

193

121444

1311

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

June-27-12 3:19:05 PM

Page 4

Work Order ID: 86339

Parent Item: D206-559-011

Parent Item Name: Bearpaw

86339

D206-559-011

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 5.00

Required Qty: 5.00

QS200-M44S

Purchased

No

160

Each

41 0000

10

✓

S *QS200-M44S*
160 clamp



JB 12/07/06

Location

Loc Qty

Loc Code

ST455

41

115589

1

119436

15

121068

25

121068

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 REV. K OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 2 OR EARLIER
REF. TCCA STC: SH92-17
REF. FAA STC: SH1031NE

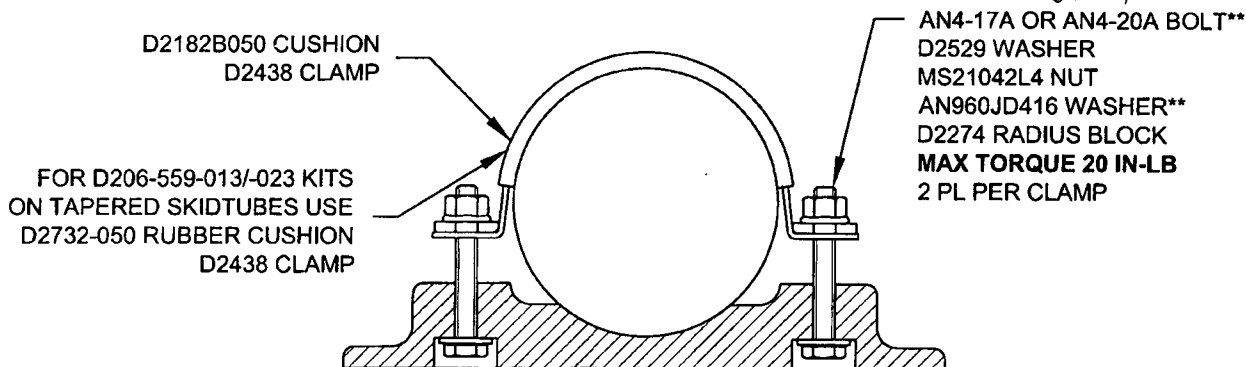
PURPOSE:

For D206-559-011/-013/-021/-023/-031/-033 bearpaw kits, the AN4 bolts specified were for installation with the aft skidtube wearshoe removed. Bolt lengths are increased to accommodate installation with the skidtube wearshoe installed, which is more practical.

CHANGE:

The parts list is updated as shown on sheet 2 of this service instruction, for bearpaw kits: D206-559-011 at CHG 007, D206-669-013 at CHG 006, D206-559-021 at CHG 008, D206-559-023 at CHG 007, D206-559-031 at CHG 002, and D206-559-033 at CHG 002.

Figure 4 of D206-559 and Figure 32-3 of ICA-D206-559 are amended as follows:



**USE AN4-17A BOLTS WITH AN AN960JD416 (OR NAS1149D0463J) WASHER IF INSTALLING BEARPAW ON 3.0" DIA. TUBE OR SMALLER. USE AN4-20A BOLTS WITH TWO AN960JD416 WASHERS IF INSTALLING BEARPAW ON TUBE LARGER THAN 3.0" DIAMETER (DART TUBE). ADDITIONAL AN960JD416 WASHERS MAY BE ADDED UNDER NUT TO ENSURE 2-4 THREADS IN SAFETY. IT IS ALSO ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS IF REQUIRED TO ENSURE BEARPAW IS HELD SECURELY.

FIGURE 4: TYPICAL CLAMPING DETAIL (D206-559)
FIGURE 32-3: TYPICAL CLAMPING DETAIL (ICA-D206-559)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	10.06.30
CERT. NO.:	SH92-17
ISSUE NO.:	7

A	NEW ISSUE	CP	10.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)






Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

06339

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

/Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP